

20565



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T103388-101-103
Job Sheet 203533



Part No: RB T103388-101-103

Job Qty: 25 pcs

Part Name: Alignment Tail Rotor Driveshaft Bolt

29 pcs

DAS
21
9-89



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 1/15/20

Type: SOLD

Description:

Note: DWG T103388-101 Rev.A IPP Rev. A 19.01.25 New issue DP Verify DD/IPP Rev. B 19.06.04 drawing revision
DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	SL-154 - 1	25 pcs	1/15/20	1/15/20	1.00	6.25	SL-154 - 1	JB 19-08-01
110	QC 2	25 pcs	1/15/20	1/15/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	JB 19-12-01
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	

DAS
62
9-89

DAS
62
9-89

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S236390

Part: RB T103388 - 101 - 103

Job No: 203533

Serial No/Batch: S236390

Revision: A

Inspector:

Exp Date:

120 QC 8	25 pcs	1/15/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	mk 19/12/03
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Outsource - 12 - Black Oxide	25 pcs	1/15/20		GRO002-VC	2019-12-04
140 Packaging 2-1 - Receive - B4B	25 pcs	1/15/20	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	DEC 1 6 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	

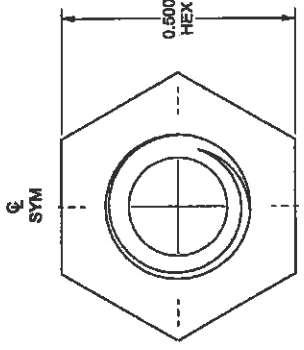
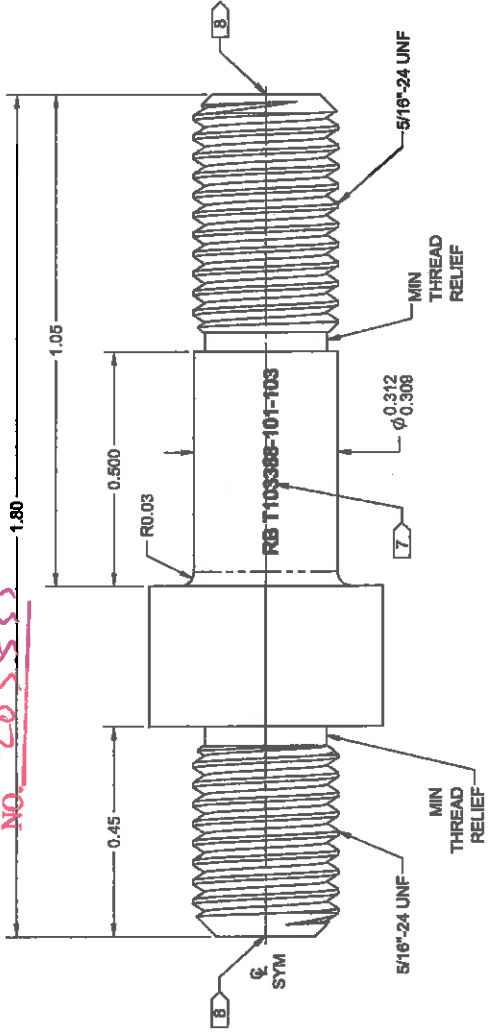
11/21/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

156	QC 6	25 pcs	1/15/20	0.00 0.00	QC 6 - 9	DAS
					QC 6 - 68	DEC 17 2019
					QC 6 - 61	9-89
					QC 6 - 40	
					QC 6 - 81	
160	Packaging 3-1 - Stock - B4B	25 pcs	1/15/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	ML
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
170	QC 21 - SA	25 pcs	1/15/20	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21 DEC 17 2019
					QC 21 - SA - 53	9-89
Part Op 100 - 1-Machine as per folio FC <u>Celeste</u> FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2-Deburr						
Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB						
120 - QC8- Inspect parts - second check						
130 - -Issue P/O; <u>45296</u> -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type;						
4140 -Certificate of Conformity is required						
140 - (Recelve & Inspect for Damage & Mat'l Certs) Certificate of Conformity is required						
150 - QC6- All purchased or subcontracted products						
160 - Identify as per dwg & Stock Location: _____						
170 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
MT-1144-R0.750	AISI 1144 Stressproof Round Bar 0.750"	4.4000 ft (.176 ea)	100-SL-154 - 1	S138866		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-SL-154 - 1	MT-1144-R0.750	4	17	0		
Part Specifications						
Specifications could not be found.						

GA
TBD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203333
19-1-21
HLS



RB T103388-101-103 BOLT

- NOTES:
- 1) MATERIAL: 1144 STRESSPROOF
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: XX = $\pm 0.1"$ / $\pm 0.1"$
XXX = $\pm 0.01"$ / $\pm 0.5"$
XXXX = $\pm 0.005"$ / $\pm 0.1"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION MACHINE ENGRAVE PIN, "RB T103388-101-103", AS SHOWN
 - 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	VM	DART AEROSPACE LTD
DRAWN	VM	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	VM	VM	REV. A
MFG. APPR.	VM	VM	TOOL PART #
APPROVED	VM	VM	RB T103388-101
DATE	2019-06-04	DATE	2019-06-04
TITLE		TRDS ALIGNMENT TOOL SET	
SCALE		NTS	
SHEET 2 OF 3		SHEET 2 OF 3	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB045296



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045296
PO Date: 12/4/19
Due Date: 12/12/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items													
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price	
1	203533	RB T103388-101-103	RB T103388-101 Rev A	Alignment Tail Rotor Driveshaft Bolt -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed 12/9	-	12/12/19	29 pcs	0 pcs	29 pcs	\$3.6363/pcs	\$105.45	



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PURCHASE ORDER
POHB045296



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	199385	RBW6305G26631-3G-3	RBW6305G26631-3G Rev 2	Handle (Outside Processing - Black Oxide) -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MIL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	12/12/19	4 pcs	0 pcs	4 pcs	\$3.6363/pcs	\$14.55
Grand Total:												\$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

D. Guerin



Certificat de Conformité / Certificate of Compliance
(024714-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

024714 - 1

Livré à / Ship to
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
12-Dec-2019	Jigar Patel		POHB045296					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	RB T103388-101-103 Rev.A	RB T103388-101 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309, TYPE - 3 OR MILL - C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS OIL	OXIDE-BLACK CH	29	29	0	0	0

RECEIVED
DEC 12 2019
DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

J. Jigar

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.
We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.